

*FAIP*

**Work Order ID 116171**

Monday, April 07, 2014 11:35:58 AM

**\*116171\***

Item ID: D4933-041 **D 4 9 3 3 - 0 4 1** Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: **B 1 1 6 1 7 1** Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 4/09/14 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 4/18/14 Req'd Qty: 8.00 **\*8\*** Customer:

Reference:

Approvals: Process Plan: *AA* Date: *140407* Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4933	<i>pa4</i>	<i>REV. A W</i>

110	FLOW WATER JET	0.00							
<b>*110*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4933-1 as per Dwg								
<i>304-063</i>	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

OAS  
27  
9:39

*14/4/14*

*12 0 Jm14-04-12*

*12 0 Jm14-04-12*

*12*

**Work Order ID 116171**

Monday, April 07, 2014 11:35:58 AM

**\*116171\***

Page 2

Item ID: D4933-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

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Start Date: 4/09/14 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 4/18/14 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

**\*140\***

Brake NC

Brake NC

Form as per dwg  
NC BRAKE

Memo

0.00

0.00

DAS  
30  
9-89

12

14/04/14

150

**\*150\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS  
27  
9-89

14/4/14

10

160

**\*160\***

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: M120854  
Large Fab

Memo

0.00

WELD BAR ON PLATE AS PER DWG

12

14-04-24

MAL/mel

**Work Order ID 116171**

Monday, April 07, 2014 11:35:58 AM

**\*116171\***

Page 3

Item ID: D4933-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Wearplate Assembly

Stop **\*NS2\***

Start Date: 4/09/14 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 4/18/14 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

(12) 14-04-24

DAS  
9  
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

(12) 14-04-24

DAS  
9  
9-89

190

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

APPLY ROCKGUARD ON CONCAVE SURFACE AS PER DWG

N/A  
GP 14/4/24

**Work Order ID 116171**

Monday, April 07, 2014 11:35:58 AM

**\*116171\***

Page 4

Item ID: D4933-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Wearplate Assembly  
Start Date: 4/09/14 Start Qty: 8.00 **\*g\*** Cust Item ID:  
Required Date: 4/18/14 Req'd Qty: 8.00 **\*g\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
<b>*240*</b>	Packaging								
Packaging	Memo	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
<b>*250*</b>									
QC	Memo	0.00							
Quality Control									

RE 4-4-25

# Picklist Print

Monday, April 07, 2014 11:36:02 AM

Page 1

Work Order ID: 116171

**\*116171\***

Parent Item: D4933-041

**\*D4933-041\***

Parent Item Name: Wearplate Assembly

Start Date: 4/09/14

Required Date: 4/18/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.09.06 new issue DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4932-1-120		Manufactured	No				Each	0.0000		8			
<b>*D4932-1-120*</b>									<b>**</b>				
KWS Carbide Wear Strip, 12" Long													
M304S16GA		Purchased	No			110	sf	196.7670	0.37	④			
<b>*M304S16GA*</b>									<b>**</b>				
304/316 Sheet .063													

B116016 X12

14923

Jm14-04-12

## Location

## Loc Qty

## Loc Code

MAT020

196.767

M126915

1.487

M127821

122.53

M128054

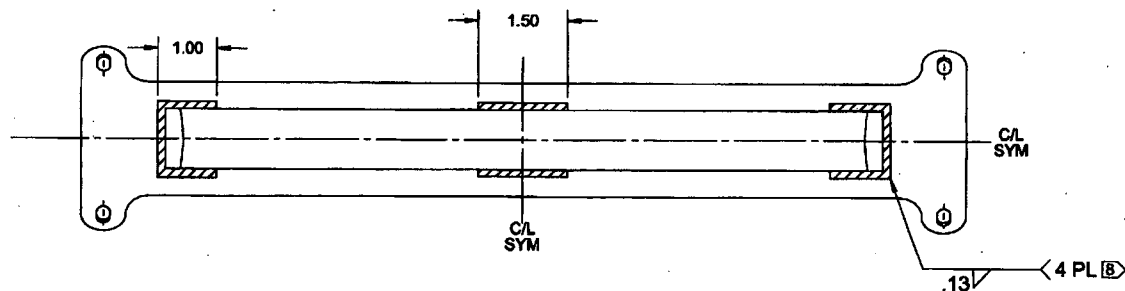
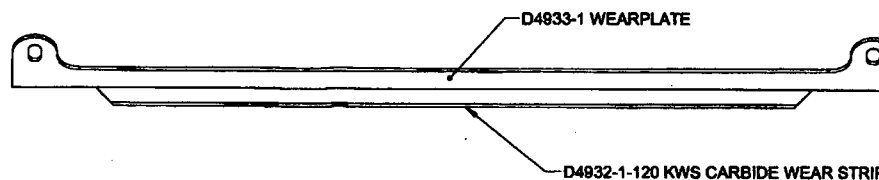
33.89

M128423

38.86

128423

ITEM	QTY	P/N	DESCRIPTION
	X	D4933-041	WEARPLATE ASSY
1	1	D4933-1	WEARPLATE
2	1	D4932-1-120	KWS CARBIDE WEAR STRIP



**D4933-041 WEARPLATE ASSY**

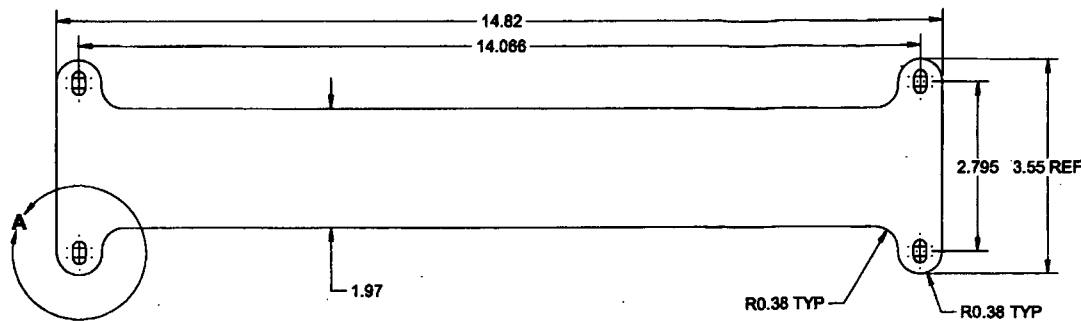
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4933-041" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.36 lbs
- 8) WELDING: PER QSI 004

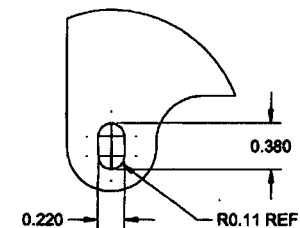
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RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 116171  
14-04-07

RELEASED  
2014-04-03  
JMP

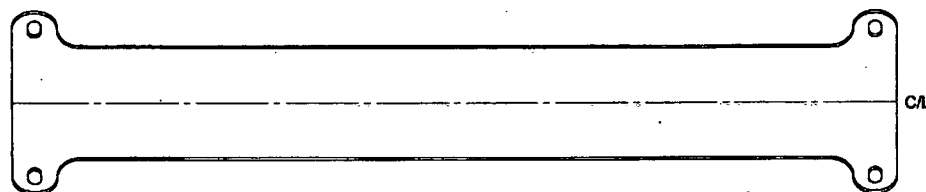
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A	NEW ISSUE	DB	13.09.09
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	DB	D4933	SHEET 1 OF 2
APPROVED	DB	TITLE	SCALE
DE APPR.	DB	WEARPLATE	NTS
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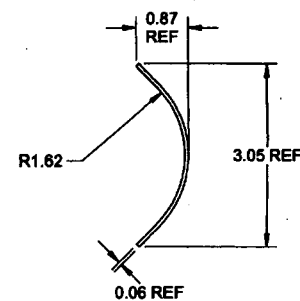
**D4933-1F FLAT PATTERN**



**DETAIL A**  
SCALE 2X  
4 PL



**D4933-1 WEARPLATE**  
(MAKE FROM D4933-1F)



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 18 GAUGE (0.083 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240 OR MIL-S-5059  
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

**RELEASE**  
2014-04-03

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